

Date: Wednesday, 08/10/2008 2:00:19 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 42513
 Estimate Number : 10437
 P.O. Number :
 This Issue : 08/10/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : SMALL / MED FAB
 Previous Run : 41938
 Drawing Name : WEARPLATE
 Part Number : D33191
 Drawing Number : D3319 REV. B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 25/10/2008 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : JUL 08.10.08
 Comment : Est: B 05.10.14 Added step 9, dwg rev B KJ/EC
 Est Rev:C Now on Waterjet 06-10-26 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S18GA 1010/1025 SHEET .048



Comment: Qty.: 0.6594 sf(s)/Unit Total: 7.9128 sf(s)
 1010/1025/A21/6aA SHEET .048
 Batch: 10437 B 8-10-16

2.0 WATER JET 101022 FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3319
 Dwg Rev: B
 Prog Rev: B

B 8-10-16

2-Deburr if necessary B 8-10-16

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary

n/a Done at step #2.2

S 08/10/17

Process Sheet

Ship today 21/10

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 42513

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

2- Form flat on press using DT8776 block

Sp 08/10/20

(3)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Sp 08/10/20 (3)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description Batch

A/R N/A 7560 Hardcoat Rod

11107553

EL 8-10-20

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

Sp 08-10-21

Sp 08/10/21

(X3)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sp 08/10/21 (X3)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-40
320 OF
9-10

M-L 08/10/21

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-10-21

(3X)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 42513

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18
and StockLocation: ST496

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

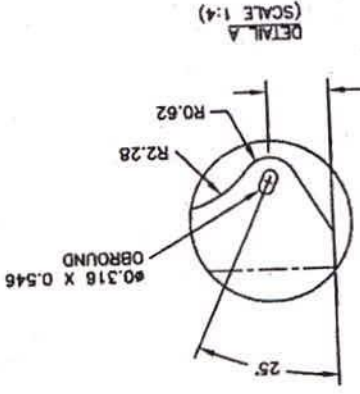
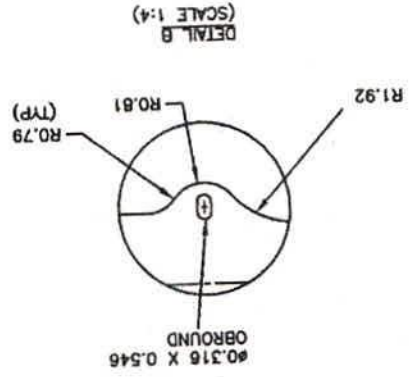
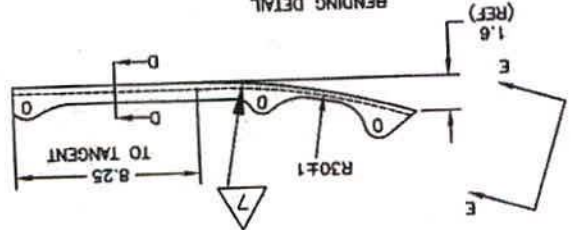
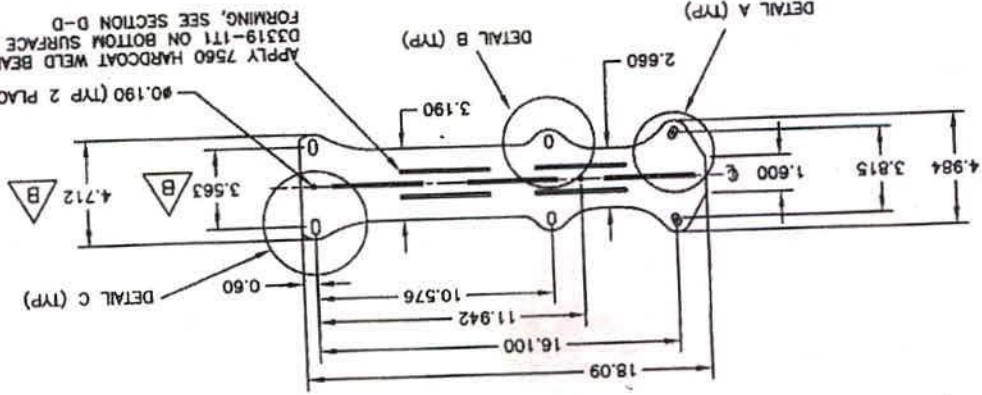
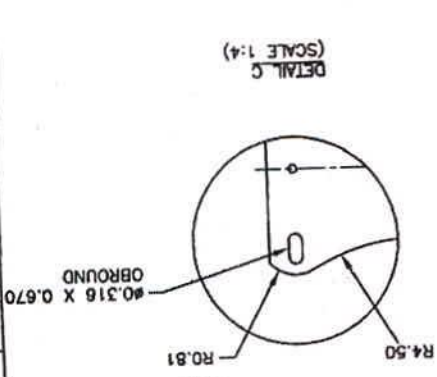
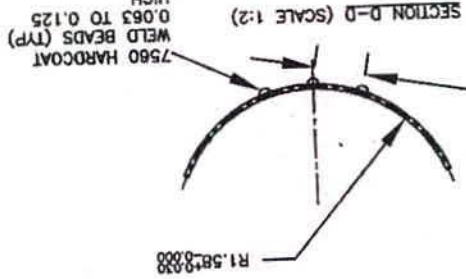
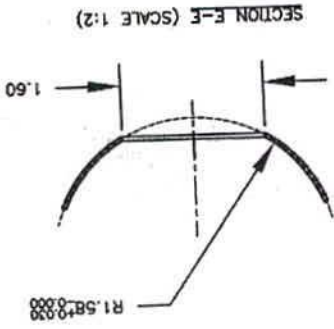
Job Completion



MF 08-10-21

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
PH	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3319
DATE	TITLE	SCALE
05.06.06	WEARPLATE	1:8
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7



- 03319-1 WEARPLATE
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) PART IS SYMMETRICAL ABOUT CENTERLINE
 - 5) ALL DIMENSIONS IN INCHES
 - 6) WELD PER DART QSI 004
 - 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18

RELEASED

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